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(54) **FUEL DELIVERY**

(57) A fuel delivery system (201) is shown for delivering the hydrogen fuel from a cryogenic storage system to a fuel injection system in a gas turbine engine. The fuel delivery system includes a pump (301), a metering

device (302), and a fuel heating system (303,304) for heating the hydrogen fuel to an injection temperature for the fuel injection system.

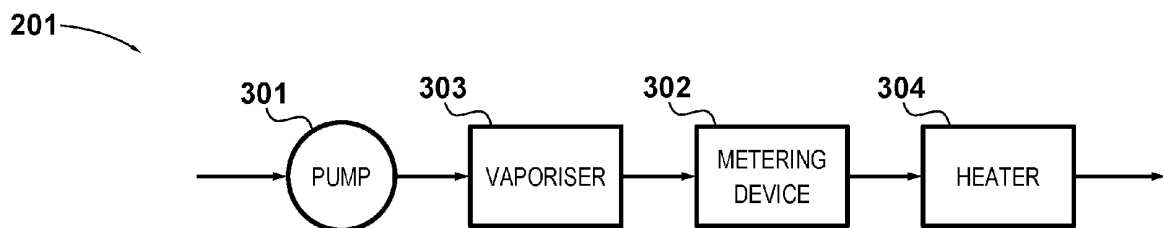


FIG. 3

Description

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims priority from United Kingdom Patent Application Nos 20 15 452.2, 20 15 453.0, and 20 15 454.8, all filed September 30, 2020, and United Kingdom Patent Application No 20 17 014.8 filed October 27, 2020, each of which is incorporated herein by reference in its entirety.

TECHNICAL FIELD

[0002] This disclosure relates to fuel delivery for hydrogen-fuelled aero gas turbine engines.

BACKGROUND

[0003] In order to limit emissions of carbon dioxide, use of hydrogen as an alternative to hydrocarbon fuel in gas turbine engines has historically only been practical in land-based installations. Such engines are typically supplied with hydrogen derived from natural gas via concurrent steam methane reformation, which hydrogen is injected into large-volume series staged dry low NO_x burners. This type of burner is not suitable for use in an aero engine primarily due to its size and the difficulties in maintaining stable operation during transient manoeuvres.

[0004] Experimental programmes have been conducted to develop aero engines operable to be fuelled with hydrogen, however these have typically been high-Mach afterburning turbojets or expander cycles and thus not practical for use on civil airliners operating in the Mach 0.8 to 0.85 regime.

[0005] There is therefore a need for technologies for combustion of hydrogen in aero gas turbine installations, in particular around the overall engine cycle to for example minimise fuel consumption, the fuel delivery system to for example meter fuel accurately, and the fuel injection system to for example minimise emissions.

SUMMARY

[0006] The invention is directed towards fuel delivery systems for delivering hydrogen fuel from a cryogenic storage system to a fuel injection system in a gas turbine engine, gas turbines incorporating such fuel delivery systems, and methods of delivering hydrogen fuel from cryogenic storage systems.

[0007] One such fuel delivery system includes a pump, a metering device, and a fuel heating system for heating the hydrogen fuel to an injection temperature for the fuel injection system.

[0008] In an embodiment, the fuel heating system comprises a vaporiser configured to vaporise liquid hydrogen from the cryogenic storage system.

[0009] In an embodiment, the vaporiser comprises a

fuel offtake for diverting a portion of the hydrogen fuel from a fuel conduit for combustion in a burner located in heat exchange relationship with the fuel conduit.

[0010] In an embodiment, the burner is configured to receive pressurised air from a compressor of the gas turbine engine for combustion with the portion of the hydrogen fuel

[0011] In an embodiment, the vaporiser comprises a boil volume or an electric heating element for initial heating of liquid hydrogen if no vaporised hydrogen fuel is available for combustion.

[0012] In an embodiment, the metering device is a fixed orifice and flow rate is controlled by varying the pressure ratio across the orifice.

[0013] In an embodiment, the metering device comprises a sonic fixed orifice configured to operate in a choked condition, and flow rate is controlled by varying pressure upstream of the sonic fixed orifice.

[0014] In an embodiment, the vaporiser is configured to raise the temperature of the hydrogen fuel to the injection temperature, and the metering device is configured to meter at the injection temperature.

[0015] In an embodiment, the vaporiser is configured to raise the temperature of the hydrogen fuel to a metering temperature less than the injection temperature, and the heating system further comprises a heater for further heating of the hydrogen fuel to the injection temperature following metering by the metering device.

[0016] In an embodiment, the heater comprises a fuel offtake for diverting a portion of the hydrogen fuel from a fuel conduit for combustion in a burner located in heat exchange relationship with the fuel conduit.

[0017] In an embodiment, the heating system comprises one or more heat exchangers for heating the hydrogen fuel by heat from the gas turbine.

[0018] In an embodiment, the one or more heat exchangers are oil-fuel heat exchangers for cooling engine oil or gearbox oil from the gas turbine engine by the hydrogen fuel.

[0019] One such gas turbine engine comprises a combustor, a fuel injection system, and a fuel delivery system for delivering hydrogen fuel from a cryogenic storage system to the fuel injection system, and in which the fuel delivery system comprises a pump, a metering device, and a fuel heating system for heating the hydrogen fuel to an injection temperature for the fuel injection system.

[0020] In an embodiment, the fuel heating system comprises a vaporiser configured to vaporise liquid hydrogen from the cryogenic storage system.

[0021] In an embodiment, the vaporiser comprises a fuel offtake for diverting a portion of the hydrogen fuel from a fuel conduit for combustion in a burner located in heat exchange relationship with the fuel conduit.

[0022] In an embodiment, the burner is configured to receive pressurised air from a compressor of the gas turbine engine for combustion with the portion of the hydrogen fuel.

[0023] One such method of delivering hydrogen fuel

from a cryogenic storage system to a fuel injection system in a gas turbine engine comprises:

pumping the hydrogen fuel from the cryogenic storage system;
 heating the hydrogen fuel to an injection temperature for the fuel injection system;
 metering the quantity of fuel for delivery to the fuel injection system.

[0024] In an embodiment, the heating of the hydrogen fuel comprises vaporising the fuel by:

diverting a portion of the hydrogen fuel from a fuel conduit;
 burning the portion of the hydrogen fuel to produce combustion products;
 transferring heat from the combustion products to the hydrogen fuel in the fuel conduit.

[0025] In an embodiment, vaporising the fuel further comprises receiving pressurised air from a compressor of the gas turbine engine for burning with the portion of the hydrogen fuel.

BRIEF DESCRIPTION OF THE DRAWINGS

[0026] Embodiments will now be described by way of example only with reference to the accompanying drawings, which are purely schematic and not to scale, and in which:

Figure 1 shows a hydrogen-fuelled airliner comprising hydrogen-fuelled turbofan engines;
 Figure 2 is a block diagram identifying the flow of hydrogen fuel;
 Figure 3 shows a fuel delivery system;
 Figure 4 shows a fuel-oil heat exchange arrangement for the fuel heating system of the fuel delivery system of Figure 3;
 Figure 5 shows a vaporiser of the fuel delivery system of Figure 3;
 Figure 6 shows a metering device of the fuel delivery system of Figure 3;
 Figure 7 shows a complex cycle including a recuperator;
 Figure 8 shows another complex cycle including a recuperator and a fuel turbine;
 Figure 9 shows another complex cycle including a recuperator and recuperative combustor cooling including a recuperator;
 Figure 10 shows another complex cycle including an intercooler and twin-pass recuperation;
 Figure 11 shows another complex cycle including an intercooler, recuperation and inter-turbine reheat;
 Figures 12A and 12B show two possible arrangements of the fuel injection system of the engines of Figure 1;

Figures 13A and 13B show two embodiments of a rim injector block;

Figure 14A shows the one configuration of the rim injector in cross section and Figure 14B shows simulated equivalence ratios downstream of the rim injector of Figure 14A;

Figure 15A shows the one configuration of the rim injector in cross section and Figure 15B shows simulated equivalence ratios downstream of the rim injector of Figure 15A;

Figure 16 shows an embodiment of a converging jet injector block;

Figure 17A shows the converging jet injector block in cross section and Figure 17B shows simulated equivalence ratios downstream of the converging jet injector block of Figure 17A;

Figures 18A and 18B show two embodiments of a jet matrix injector block;

Figure 19A shows the jet matrix injector block in cross section and Figure 19B shows simulated equivalence ratios downstream of the jet matrix injector block of Figure 19A; and

Figures 20A and 20B show the invariance of injector block size with power scaling of engine and fuel injection system.

DETAILED DESCRIPTION

[0027] A hydrogen-fuelled airliner is illustrated in Figure 1. In this example, the airliner 101 is of substantially conventional tube-and-wing twinjet configuration with a central fuselage 102 and substantially identical under-wing-mounted turbofan engines 103.

[0028] In the present embodiment, the turbofan engines 103 are geared turbofan engines. A hydrogen storage tank 104 located in the fuselage 104 for hydrogen fuel supply is connected with core gas turbines 105 in the turbofan engines 103 via a fuel delivery system. In the present embodiment, the hydrogen storage tank 104 is a cryogenic hydrogen storage tank and thus stores the hydrogen fuel in a liquid state, in a specific example at 20 kelvin. In this example, the hydrogen fuel is pressurised to a pressure from around 1 bar to around 3 bar, in a specific example 2 bar.

[0029] A block diagram identifying the flow of hydrogen fuel is shown in Figure 2.

[0030] Hydrogen fuel is obtained from the hydrogen storage tank 104 by the fuel delivery system 201 and supplied to each core gas turbine 105. In the Figure, only one of the core gas turbines is shown for clarity. In this illustrated embodiment, the core gas turbine 105 is a simple cycle gas turbine engine. In other embodiments, as will be described with reference to Figures 7 to 11, complex cycles may be implemented via fuel-cooling of the gas path.

[0031] Referring again to Figure 2, the core gas turbine 105 comprises, in fluid flow series, a low-pressure compressor 202, an interstage duct 203, a high-pressure

compressor 204, a diffuser 205, a fuel injection system 206, a combustor 207, a high-pressure turbine 208, a low-pressure turbine 209, and a core nozzle 210. The high-pressure compressor 204 is driven by the high-pressure turbine 208 via a first shaft 211, and the low-pressure compressor 203 is driven by the low-pressure turbine 209 via a second shaft 212. It will be appreciated that in alternative embodiments, the core gas turbine could be of three-shaft configuration.

[0032] As will be described further with reference to Figure 12A onward, the fuel injection system 206 may be a direct fuel injection system.

[0033] As described previously, in the present embodiment, the turbofan engines 103 are geared turbofan engines. Thus in operation the low-pressure turbine 209 drives a fan 213 via a reduction gearbox 214. The reduction gearbox receives input drive from the second shaft 212 and provides output drive to the fan 213 via a fan shaft 215. In an embodiment, the reduction gearbox 214 is an epicyclic reduction gearbox. In a specific embodiment, it is a planetary reduction gearbox. Alternatively, it may be a star reduction gearbox, or a compound epicyclic reduction gearbox. As a further alternative, the reduction gearbox 214 could be a layshaft-type reduction gearbox or any other type of reduction gearbox. It will also be appreciated that the principles disclosed herein may be applied to a direct-drive type turbofan engine, i.e. in which there is no reduction gearbox between the low-pressure turbine and the fan.

Fuel Delivery System

[0034] In operation, the fuel delivery system 201 is configured to obtain hydrogen fuel from the hydrogen storage tank 104 and provide it to the fuel injection system 206 in the core gas turbine 105. Figure 3 is a block diagram illustrating the fuel delivery system 201 in greater detail.

[0035] The fuel delivery system 201 comprises a pump 301, a metering device 302, and a fuel heating system for heating the hydrogen fuel to an injection temperature for the fuel injection system 206. In an embodiment, a vent system (not shown) may be included in the fuel delivery system 201 close to the fuel injection system 206 to vent hydrogen fuel should a rapid shut-off be required, for example in response to a shaft-break event. It is envisaged that the vent system may vent the excess hydrogen fuel into the bypass duct of the turbofan engine 103, or alternatively vent it outside of the nacelle of the engine 103. An igniter may be provided to flare off the excess hydrogen in a controlled manner.

[0036] In the present embodiment, the pump 301 is high-speed centrifugal pump. In a specific embodiment, it is configured to operate at 50000 rpm or more. In a specific embodiment, the centrifugal pump comprises an axial inducer to minimise the required inlet pressure and to accommodate multiphase flow in addition to the centrifugal impeller for developing the majority of the required pressure rise. In an alternative embodiment, a piston-

type pump could be used.

[0037] In an embodiment, the pump 301 is located in the hydrogen storage tank 104. In this way leakage of hydrogen fuel past pump seals etc. is accommodated.

[0038] In an embodiment, the pump 301 is driven by a fuel turbine, as will be described with reference to Figure 8.

[0039] Alternatively, the pump 301 could be driven by an air turbine supplied with compressor bleed, for example bleed from the high-pressure compressor 204. Alternatively, combustion products from the combustor 207 may be used to drive a dedicated turbine for driving the pump 301. In another embodiment, the pump 301 is driven via an electrical machine. In an embodiment, the drive means for the pump 301 are also located in the hydrogen storage tank 104.

[0040] In this embodiment, the metering device 302 is configured to meter the required quantity of fuel for the current fuel demand of the core gas turbine 105.

[0041] As will be appreciated, it is desirable to increase the temperature of the fuel from the 20 kelvin cryogenic storage condition to a temperature much closer to the firing temperature of the core gas turbine; of course this is subject to the constraint of not exceeding the autoignition temperature of the hydrogen fuel prior to admission into the combustor 207. In an example, the injection temperature is from 250 to 300 kelvin, for example 280 kelvin.

[0042] In the present embodiment, the fuel heating system comprises a vaporiser 303 for heating of the hydrogen fuel to implement a phase change. In the present embodiment, this takes place between the pump 301 and the metering device 302. In this way the metering device 302 meters gaseous hydrogen fuel. It is contemplated that in other embodiments, the order of operations may change.

[0043] In an embodiment, the vaporiser 303 is configured to raise the temperature of the hydrogen fuel to the required injection temperature. Thus, in such a configuration, the metering device 302 meters the hydrogen fuel at the injection temperature.

[0044] In another embodiment, the vaporiser 303 is configured to raise the temperature of the hydrogen fuel to a metering temperature less than the injection temperature. This could for example be from 100 to 200 kelvin, for example 150 kelvin. This reduces the risk of damage to electronic devices used for sensing temperature, pressure etc.

[0045] Further heating is implemented following the metering of hydrogen fuel by the metering device 302. In this example, this is achieved with a heater 304. The configuration of the vaporiser 303 and heater 304 may be substantially similar, and an example will be described further with reference to Figure 10.

[0046] Additionally or alternatively, the fuel heating system may comprise one or more heat exchangers for raising the temperature of the hydrogen fuel by use of rejected heat from the core gas turbine 105. As will be described further with reference to Figures 7 to 11, this

may be achieved by implementing a complex cycle configuration, for example fuel recuperation, intercooling, etc.

[0047] However, even in a simple cycle configuration as contemplated herein, this fuel heating may be achieved by, for example, cooling one or more of the various oil systems in the core gas turbine 105. A specific example of such a configuration is shown in Figure 4, in which the fuel heating system comprises a fuel-oil heat exchanger 401 for cooling lubricating oil from the reduction gearbox 214. In an example, even with a 99 percent efficient gearset, at maximum thrust it may still be required to reject around 750 kilowatts of heat from the gearbox oil system, which represents a significant opportunity for raising the temperature of the hydrogen fuel. It will be appreciated that other engine oil, such as main bearing lubrication oil, may also be cooled in a similar manner. It will also be appreciated that cooling air systems may be cooled in a similar manner, with high-pressure compressor 204 discharge air being cooled by heat exchange with the hydrogen fuel prior to being delivered to the high-pressure turbine 208 for cooling thereof.

[0048] In a simple cycle configuration it has been determined that due to the significant heat capacity of the hydrogen fuel, even if it is utilised as a heatsink for engine waste heat, it will still not reach the required injection temperature without implementation of the vaporiser 303 and optionally the heater 304, depending on the chosen metering temperature. Further, even in a complex cycle configuration in which the heat of combustion products is recuperated into the hydrogen fuel, it has been determined that at certain points in the operational envelope there will be insufficient heat output from the engine to raise the fuel temperature to the injection temperature. Such occasions may include, for example, ground start, in-flight relight, end of cruise idle, etc.

[0049] An example configuration of the vaporiser 303 is shown in Figure 5. Such a configuration may also be used for the heater 304.

[0050] The vaporiser 303 comprises an offtake 501 from a main fuel conduit 502. The amount of hydrogen bled from the main fuel conduit 502 is controlled by a valve 503. In operation, of the order of around 1 percent of the hydrogen fuel flow through the main fuel conduit 502 is bled for use in the vaporiser 303.

[0051] As described previously, hydrogen has very high specific and latent heat capacities; however as a gas it has a very low molecular weight and density, and thus it can be challenging to exchange heat in a compact way. Thus the vaporiser 303 vaporises the hydrogen fuel in the main fuel conduit 502 by combustion of the bled fuel in a burner 504 located in heat exchange relationship with the main fuel conduit 502. In the present embodiment, the burner 504 is concentric around the main fuel conduit 502, although it will be appreciated that other arrangements are possible.

[0052] In the present embodiment, air for combustion with the bled hydrogen fuel is bled from the high-pressure

compressor 204. Alternatively, it may be bled from the low-pressure compressor 202. It will be appreciated that the air for combustion could be obtained from any other suitable location.

[0053] In the present example, the air and the bled hydrogen fuel are mixed in a premixer 505, although in alternative embodiments it may be directly co-injected into the burner with the hydrogen fuel instead. Combustion products from the burner 504 are, in an embodiment, exhausted into the bypass duct of the turbofan engine 103. Alternatively, they may be exhausted outside the nacelle.

[0054] It should be understood that, in the present example, the products of combustion from the burner 504 are not mixed with the fuel in the main fuel conduit 502. In this respect, the vaporiser 303 therefore differs from a pre-burner system as used in staged combustion cycle rocket engines.

[0055] In steady state, there is enough heat emanating from the burner 504 to ensure vaporisation of the small amount of bled hydrogen fuel. At engine start or other cold conditions for example, the vaporiser 303 comprises a preheater 506 to ensure vaporisation of the bled hydrogen fuel prior to mixing with air in the premixer 505. In a specific embodiment, the preheater 506 comprises an electric heating element, for example a coil. Alternatively, the preheater 506 could be simply configured as a boil volume, in which the ambient conditions therein contain sufficient enthalpy to boil the initial flow of bled hydrogen fuel prior to delivery to the premixer 505 and the burner 504.

[0056] Embodiments of the metering device 302 are illustrated in Figures 6A and 6B.

[0057] Fuel flow on a conventional liquid-fuelled aero engine is typically controlled by means of a pressure regulating valve and a profiled translating spill valve which returns a proportion of the flow supplied by the pump back to the pump inlet. However, because hydrogen has an extremely low density and viscosity, it has a strong tendency to leak through any gap. A control system that relies on close clearances to minimise leakages will be highly problematic with hydrogen as the fuel, since there will be significant leakage with even very tight clearances and the significant thermal variations in a hydrogen system will preclude very tight clearances.

[0058] In the present embodiments, therefore, the metering device 302 uses a fixed orifice which inherently has no moving parts and may therefore be sealed.

[0059] A first embodiment of the metering device 302 is shown in Figure 6 and comprises a choked sonic orifice 601 located in the main fuel conduit 302. Thus, in operation, the flow is through the orifice is choked, i.e. it has a Mach number of 1. The flow is therefore a function only of the area of the orifice and upstream pressure and temperature, measured in this embodiment by a sensor 602. In order to ensure the orifice remains choked, the orifice 601 comprises an exit with no expansion, i.e. it is sharp-edged, and the ratio of upstream to downstream pres-

tures is set to be at least the critical pressure ratio which, for hydrogen (a diatomic gas) is around 1.9.

[0060] Flow control is then achieved simply by adjusting the upstream pressure delivered by the pump 301, the upstream temperature being measured and the orifice area being known.

[0061] As an alternative, the metering device 302 could comprise a fixed but unchoked orifice across which a pressure differential may be measured across upstream and downstream taps using an appropriate sensor. Mass flow may then be derived with knowledge of upstream and downstream pressures and temperatures and the geometry of the fixed orifice.

Complex Cycles

[0062] As described previously, it is envisaged that the fuel delivery system 201 and fuel injection system 206 may be used in an embodiment of the core gas turbine 105 implementing a simple cycle as described with reference to Figure 2, possibly with fuel cooling of engine or gearbox oil or cooling air. Alternatively, the core gas turbine engine 105 may implement a complex cycle.

[0063] A first embodiment of such a complex cycle is shown in Figure 7 with like reference numerals used for matching features. In this example, the turbofan engine 103 and core gas turbine 105 are unchanged from their arrangement in Figure 2, save for the addition of a recuperator 701 located between the low-pressure turbine 209 and core nozzle 210. The recuperator 701 forms part of the fuel heating system and is operable to heat hydrogen fuel by the exhaust stream of the core gas turbine 105. In this way, less fuel may be required to heat the hydrogen fuel to the injection temperature, increasing cycle efficiency.

[0064] In an embodiment, the recuperator 701 is a spiral-wound recuperator, which reduces the likelihood of fracture due to thermal expansion and contraction.

[0065] Another embodiment of a complex cycle is shown in Figure 8, which builds on the cycle of Figure 7 with the inclusion of a fuel turbine 801. It will be appreciated that substantial energy recovery may be achieved from the exhaust stream if it is accepted that less thrust will be developed by the core nozzle 210. Thus, it is possible to heat the hydrogen fuel beyond the required fuel injection temperature and to recover work in the fuel turbine 801, which may be used to drive a load 802. In this example the load 802 is an electrical generator. In a specific embodiment, the electrical generator powers the fuel pump 301. Alternatively, the load could be the second shaft 212, with an appropriate drive mechanism being provided. In this way, the fuel turbine 801 augments the low-pressure turbine 209. It will be appreciated that other engine loads such as oil pumps etc. could also be driven by the fuel turbine 801.

[0066] Additionally or alternatively, as shown in Figure 9 it is possible perform further recuperation by using the hydrogen fuel to cool the combustor 207. Gas turbine

combustors feature a liner needs to be cooled to maintain its mechanical integrity.

[0067] In conventional liquid-fuelled aero engines the combustor liner is cooled by the airflow drawn from atmosphere and which has passed through the compression system. This is typically via a single pass system in which the air passes through holes in the liner and to enter the main heat release region. Hence this air cannot be part of the combustion process and therefore leads to an increase in emissions and a decrease in cycle efficiency.

[0068] Thus, in an embodiment, the hydrogen fuel is flowed around the liner of the combustor 207. This scheme may be achieved by provision of for example helical cooling channels around the combustor 207 through which the hydrogen fuel may flow prior to injection.

[0069] Additionally or alternatively, as shown in Figure 10 it is possible to provide intercooling and twin-pass recuperation.

[0070] In this embodiment, an intercooler 1001 is provided in the interstage duct 203 between the low-pressure compressor 202 and the high-pressure compressor 204 for cooling low-pressure compressor discharge air by the hydrogen fuel. In this way, the amount of compression work required to be performed by the high-pressure compressor 204 is reduced.

[0071] In this specific embodiment, a second recuperator 1002 is provided between the low-pressure turbine 209 and the recuperator 701 for further recuperative heating of the hydrogen fuel.

[0072] Thus, in this example, hydrogen fuel is first heated by the recuperator 701 to a temperature less than the low-pressure compressor 202 discharge air, which heats it further in the intercooler 1001. Further heating occurs in the second recuperator 1002, which has an inlet temperature higher than the recuperator 701. In this way, the temperature difference between the hydrogen fuel and the core gas turbine exhaust temperature is maximised in each recuperator.

[0073] Additionally or alternatively, as shown in Figure 11 a sequential combustion arrangement may be implemented to facilitate inter-turbine reheat. It will be appreciated that reheat of this type comprises additional stages of combustion to raise temperatures back to a maximum cycle temperature after a first stage of expansion. Along with intercooling, this moves the overall engine cycle closer to an Ericsson cycle, improving thermal efficiency substantially. In this specific example, the high-pressure turbine 208 is a multi-stage turbine and a reheat fuel injection system 1101 and reheat combustor 1102 are stationed between two of the stages 208A and 208B of the high-pressure turbine 208. Alternatively, the reheat fuel injection system 1101 and reheat combustor 1102 may be stationed between the high-pressure turbine 208 and the low-pressure turbine 209.

Direct Fuel Injection System

[0074] Due to its wide flammability limits and reaction rates, there is significant risk of flashback in hydrogen fuel injection systems. Thus it is preferable to utilise the direct injection principle with low mixing times and high velocities, as opposed to attempting any form of premixing. In order to minimise formation of oxides of nitrogen, residence time at high temperature must also be minimised. These constraints therefore favour a miniaturisation of the individual fuel injectors, sometimes referred to as "micromix" injectors.

[0075] Figures 12A and 12B illustrate two possible arrangements of the fuel injection system 206. It will be appreciated that in the present embodiment the core gas turbine 105 employs an annular combustion system, and it will be clear how the principles disclosed herein may be adapted e.g. for tubular systems.

[0076] In the embodiment of Figure 12A, the fuel injection system 206 comprises a full annulus 1201 of fuel injector blocks 1202. In the embodiment of Figure 12B, the fuel injection system 206 comprises a plurality of sectors 1203 each comprising a subset of the totality of fuel injector blocks 1202. In both embodiments, the fuel injector blocks 1202 are configured with a geometry that substantially tessellates. It will be appreciated that the embodiment of Figure 12A will produce a substantially more uniform circumferential heat-release profile, reducing the danger of hot streaks in the combustor 207 and uneven loading of the high-pressure turbine 208, improving performance by reducing cooling requirements.

[0077] It is contemplated that the fuel injection system 206 would comprise many hundreds or even thousands of fuel injector blocks 1202. For example, in an embodiment there are from 500 to 2000 fuel injector blocks, for example 1000 fuel injector blocks 1202.

[0078] A first configuration for the fuel injector blocks 1202 will be described with reference to Figures 13A to 15B. A second configuration for the fuel injector blocks 1202 will be described with reference to Figures 16 to 17B. A third configuration for the fuel injector blocks 1202 will be described with reference to Figures 18A to 20B.

[0079] The first configuration for the fuel injector blocks is shown in Figures 13A and 13B, and will hereinafter be referred to as a rim injector block 1301. A first embodiment of the rim injector block 1301 is shown in Figure 13A, and has a quadrilateral, specifically a square, outer profile in the plane of tessellation. Another embodiment is shown in Figure 13B, and has a hexagonal, specifically a regular hexagon, outer profile in the plane of tessellation. It will be appreciated that other outer profiles that tessellate could be used. In this example, the rim injector block 1301 comprises an air admission duct 1302 and a fuel admission aperture 1303.

[0080] Referring now to Figure 14A, which is a cross sectional view on I-I of Figure 13A, the air admission duct 1302 has an inlet 1401 for receiving air A from the diffuser 205 and an outlet 1402 for delivering air into a mixing

zone in the combustor 207. The air admission duct 1302 has a central axis C extending from the inlet 1401 to the outlet 1402. The fuel admission aperture 1303 is located around the periphery of the outlet 1402 and is configured to inject hydrogen onto a jet shear layer formed at the outlet 1302 for mixing in the mixing zone. In the embodiment of Figure 14A, the fuel admission aperture 1303 is configured to inject hydrogen fuel parallel to the central axis C, as shown by arrows F. Figure 14B shows the equivalence ratios downstream of the rim injector block 1301, and was obtained by a periodic isothermal CFD simulation on this configuration. The air admission duct 1302 was sized with a 6 millimetre diameter. In this example, a uniform equivalence ratio U was achieved within 80 millimetres of the injection point.

[0081] An alternative configuration of the rim injector block 1301 is shown in Figure 15A, in which the fuel admission aperture 1303 is configured to inject hydrogen fuel perpendicular to the central axis C, as shown by arrows F. Figure 15B shows the results of a periodic isothermal CFD simulation on this configuration. Again, the air admission duct 1302 had a 6 millimetre diameter and a uniform equivalence ratio U was achieved within 80 millimetres of the injection point.

[0082] In both configurations, the injection of fuel onto the jet shear layer from the fuel admission aperture 1303 minimises flammable mixtures at velocities lower than the turbulent flame speed close to the injector. This reduces the risk of flashback.

[0083] A second configuration for the fuel injector blocks is shown in Figure 16, and will hereinafter be referred to as a converging jet injector block 1601. The converging jet injector block 1601 comprises a fuel admission duct 1602 and a plurality of air admission ducts 1603 distributed around the air admission duct. In this specific embodiment, the air admission ducts 1603 are equidistant from the fuel admission duct 1602. As described previously, the outer profile of the injector block may be configured such that multiple blocks substantially tessellate adjacent to one another.

[0084] Referring now to Figure 17A, which is a cross-sectional view on II-II of Figure 16, the fuel admission duct 1602 has a central axis C and each air admission duct 1603 has its own respective axis R defined between each duct's respective inlet and outlet. In the present embodiment, the fuel admission duct 1602 and air admission ducts 1603 are configured to respectively admit fuel and air without swirl. The respective axis R of each air admission duct 1603, is inclined towards the central axis C of the fuel admission duct 1602, such that emerging fuel F converges on the air A in the mixing zone.

[0085] Figure 17B shows the equivalence ratios downstream of the converging jet injector block 1601, and was obtained by a periodic isothermal CFD simulation on this configuration. In this example, the fuel admission duct 1602 was sized with a 0.5 millimetre diameter and the air admission ducts 1603 were sized with a 0.8 millimetre diameter. A uniform equivalence ratio U was achieved

within 30 millimetres of the injection point.

[0086] A third configuration for the fuel injector blocks is shown in Figures 18A and 18B, and will hereinafter be referred to as a jet matrix injector block 1801. The converging jet injector block 1801 comprises a fuel admission duct 1802 and a plurality of air admission ducts 1803 distributed around the air admission duct. In the present embodiment, the fuel admission duct 1802 and air admission ducts 1803 are configured to respectively admit fuel and air without swirl.

[0087] In Figure 18A, the outer profile of the jet matrix injector block 1801 is a quadrilateral and in Figure 18B it is a hexagon.

[0088] In an embodiment, the jet matrix injector block 1801 comprises a number $2N$ of air admission ducts 1803 that meet the following criteria: $2N$ is even and equal to 6 or more, i.e. $2N \geq 6$. Thus for example in Figure 18A it can be seen that $N = 4$ and thus there are 8 air admission ducts 1803, whilst in Figure 18A it can be seen that $N = 6$ and thus there are 12 air admission ducts 1803.

[0089] The air admission ducts 1803 are then distributed around the fuel admission duct 1802 such that they lie on the periphery of an N -gon (i.e. a polygon with N sides) centred on the central axis C of the fuel admission duct 1802. In a specific embodiment, N of the air admission ducts 1803 are arranged at a respective vertex of the N -gon, and the other N of the air admission ducts 1803 are arranged on a respective edge of the N -gon. For example, the other N of the air admission ducts 1803 may be arranged at the midpoint of their respective edge.

[0090] Taking Figure 18A as a worked example, $N = 4$, therefore there are $2N = 8$ air admission ducts 1803. These are located on the periphery of a 4-gon, i.e. a square. Four of the air admission ducts 1803 are located at the vertices (i.e. the corners) of the square, and the other four are located on a respective edge of the square. In this example they are located at a midpoint of the edges.

[0091] Figure 19A is a cross-sectional view on III-III of Figures 18A and 18B, in which it may be seen that in this embodiment the air admission ducts 1803 are configured to lie parallel to the fuel admission duct 1802. Thus, each air admission duct 1803 has a respective axis R defined between each duct's inlet and outlet, whilst the fuel admission duct 1802 has a central axis C defined between its inlet and outlet. The respective axes R of the air admission ducts 1803 are parallel with the central axis C .

[0092] Figure 19B shows the equivalence ratios downstream of the jet matrix injector block 1901, and was obtained by a periodic isothermal CFD simulation on this configuration. In this example, the fuel admission duct 1802 was sized with a 0.5 millimetre diameter and the air admission ducts 1803 were sized with a 0.8 millimetre diameter. A uniform equivalence ratio U was achieved within 10 millimetres of the injection point.

[0093] By defining fuel injector blocks 1202 of small scale relative to the overall size of the fuel injection system annulus, the flow field in the combustor 207 becomes

self-similar and substantially invariant over different practical sizes. An example is shown in Figure 20A and 20B of how the core gas turbine 105 may undergo a power scaling, i.e. the use of a substantially common design for two different power levels. In this example, the fuel injection system 206 is sized for an engine with power P in Figure 20A, and a power $2P$ in Figure 20B. However, it will be seen that the size of the fuel injector blocks 1202 has not changed between the two designs, there has simply been an increase of the number making up the overall annulus.

[0094] Thus, in an industrial setting, the design process for a new specification engine may simply comprise obtaining a design of a standardised fuel injector block, such as blocks 1301, 1601 and 1801. The standard specification for such an injector block would comprise its capability in terms of fuel mass flow performance and its dimensions and geometry. Engine performance data, typically derived prior to detailed component design, would set the required fuel mass flow requirements for the new engine type.

[0095] A simple evaluation of the quantity of standardised fuel injector blocks that meets the fuel mass flow requirements for the engine may then be performed. This would not require any dimensional scaling of the standardised fuel injectors, and indeed this would be discouraged as the flow field would change.

[0096] Referring again briefly to Figure 2, it can be seen that the adoption of a micromix-type direct fuel injection system as described herein facilitates a much shorter combustor 207. Thus for the same overall axial length of the core gas turbine 105, it is possible to increase the axial length available for the diffuser 205. In this way, improved control over the diffusion process may be achieved rather than the conventional dump diffuser designs utilised on conventional liquid-fuelled aero engines which require much longer combustor lengths due to the slower combustion processes associated with liquid hydrocarbon fuels. Thus in an embodiment, the axial length of the diffuser 205 is greater than the axial length of the combustor 207. In an embodiment, the diffuser is a faired diffuser which improves the uniformity of the flow delivered to the fuel injection system 206.

[0097] Various examples have been described, each of which comprise various combinations of features. It will be appreciated by those skilled in the art that, except where clearly mutually exclusive, any of the features may be employed separately or in combination with any other features and thus the disclosed subject-matter extends to and includes all such combinations and sub-combinations of the or more features described herein.

Claims

1. A fuel delivery system for delivering hydrogen fuel from a cryogenic storage system to a fuel injection system in a gas turbine engine, the fuel delivery sys-

tem including a pump, a metering device, and a fuel heating system for heating the hydrogen fuel to an injection temperature for the fuel injection system.

2. The fuel delivery system of claim 1, in which the fuel heating system comprises a vaporiser configured to vaporise liquid hydrogen from the cryogenic storage system. 5
3. The fuel delivery system of claim 2, in which the vaporiser comprises a fuel offtake for diverting a portion of the hydrogen fuel from a fuel conduit for combustion in a burner located in heat exchange relationship with the fuel conduit. 10
4. The fuel delivery system of claim 3, in which the burner is configured to receive pressurised air from a compressor of the gas turbine engine for combustion with the portion of the hydrogen fuel. 15
5. The fuel delivery system of claim 3 or claim 4, in which the vaporiser comprises a boil volume or an electric heating element for initial heating of liquid hydrogen if no vaporised hydrogen fuel is available for combustion. 20
6. The fuel delivery system of any one of claims 1 to 5, in which the metering device is one of: 25
 - a fixed orifice and flow rate is controlled by varying the pressure ratio across the orifice; or
 - a sonic fixed orifice configured to operate in a choked condition, and flow rate is controlled by varying pressure upstream of the sonic fixed orifice. 30
7. The fuel delivery system of any one of claims 1 to 6, in which the vaporiser is configured to raise the temperature of the hydrogen fuel to the injection temperature, and the metering device is configured to meter at the injection temperature. 35
8. The fuel delivery system of any one of claims 1 to 6, in which the vaporiser is configured to raise the temperature of the hydrogen fuel to a metering temperature less than the injection temperature, and the heating system further comprises a heater for further heating of the hydrogen fuel to the injection temperature following metering by the metering device. 40
9. The fuel delivery system of claim 8, in which the heater comprises a fuel offtake for diverting a portion of the hydrogen fuel from a fuel conduit for combustion in a burner located in heat exchange relationship with the fuel conduit. 45
10. The fuel delivery system of any preceding claim, in which the heating system comprises one or more

heat exchangers for heating the hydrogen fuel by heat from the gas turbine;
optionally wherein one or more heat exchangers are oil-fuel heat exchangers for cooling engine oil or gearbox oil from the gas turbine engine by the hydrogen fuel.

11. A gas turbine engine comprising a combustor, a fuel injection system, and a fuel delivery system for delivering hydrogen fuel from a cryogenic storage system to the fuel injection system, and in which the fuel delivery system comprises a pump, a metering device, and a fuel heating system for heating the hydrogen fuel to an injection temperature for the fuel injection system. 50
12. The gas turbine engine of claim 11, in which the fuel heating system comprises a vaporiser configured to vaporise liquid hydrogen from the cryogenic storage system. 55
13. The gas turbine engine of claim 11 or claim 12, in which the vaporiser comprises a fuel offtake for diverting a portion of the hydrogen fuel from a fuel conduit for combustion in a burner located in heat exchange relationship with the fuel conduit, optionally wherein the burner is configured to receive pressurised air from a compressor of the gas turbine engine for combustion with the portion of the hydrogen fuel.
14. A method of delivering hydrogen fuel from a cryogenic storage system to a fuel injection system in a gas turbine engine, comprising:
 - pumping the hydrogen fuel from the cryogenic storage system;
 - heating the hydrogen fuel to an injection temperature for the fuel injection system;
 - metering the quantity of fuel for delivery to the fuel injection system.
15. The method of claim 14, in which the heating of the hydrogen fuel comprises vaporising the fuel by:
 - diverting a portion of the hydrogen fuel from a fuel conduit;
 - burning the portion of the hydrogen fuel to produce combustion products;
 - transferring heat from the combustion products to the hydrogen fuel in the fuel conduit.

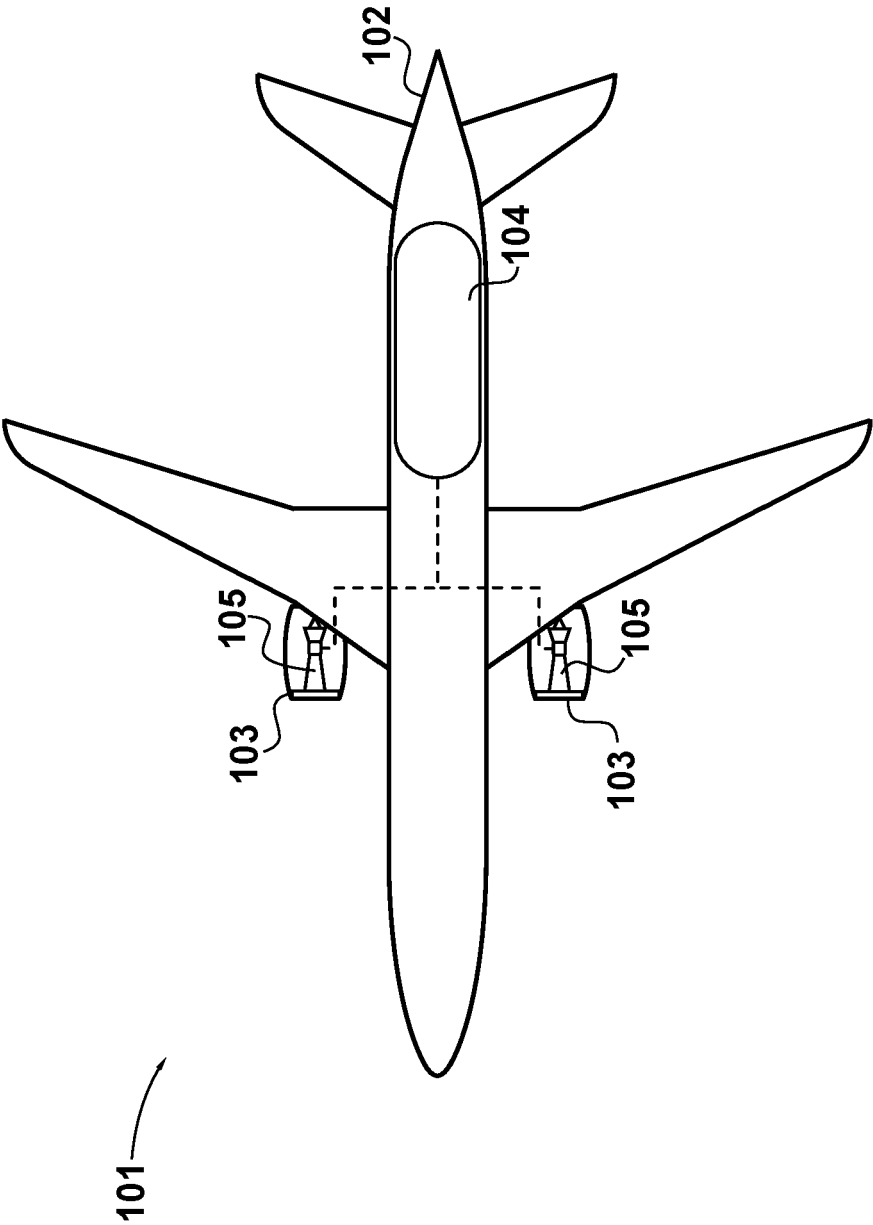


FIG. 1

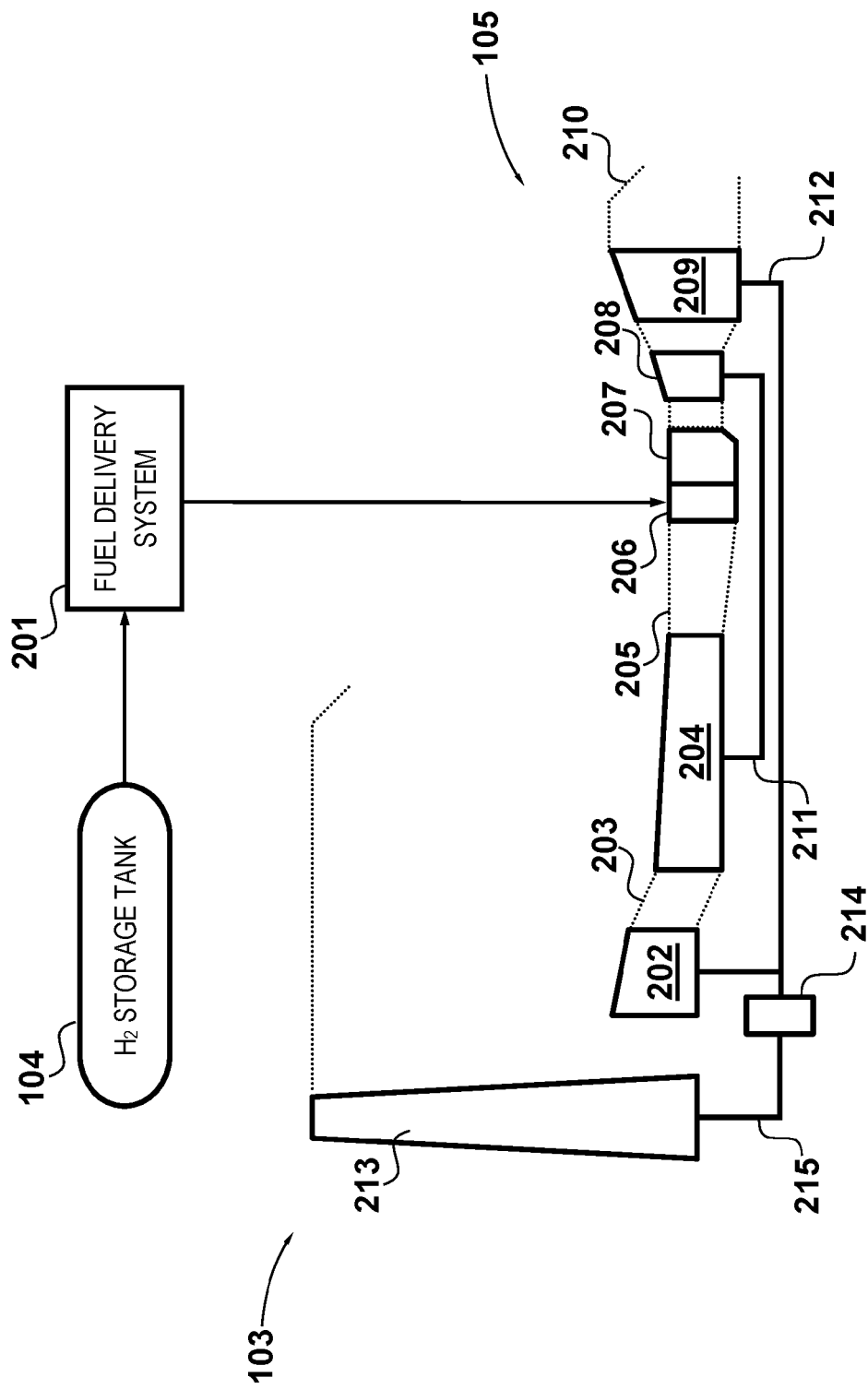


FIG. 2

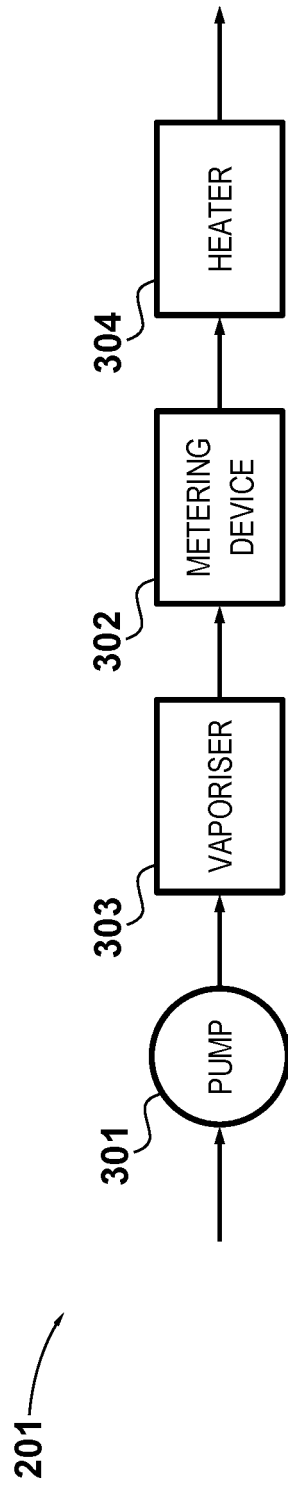


FIG. 3

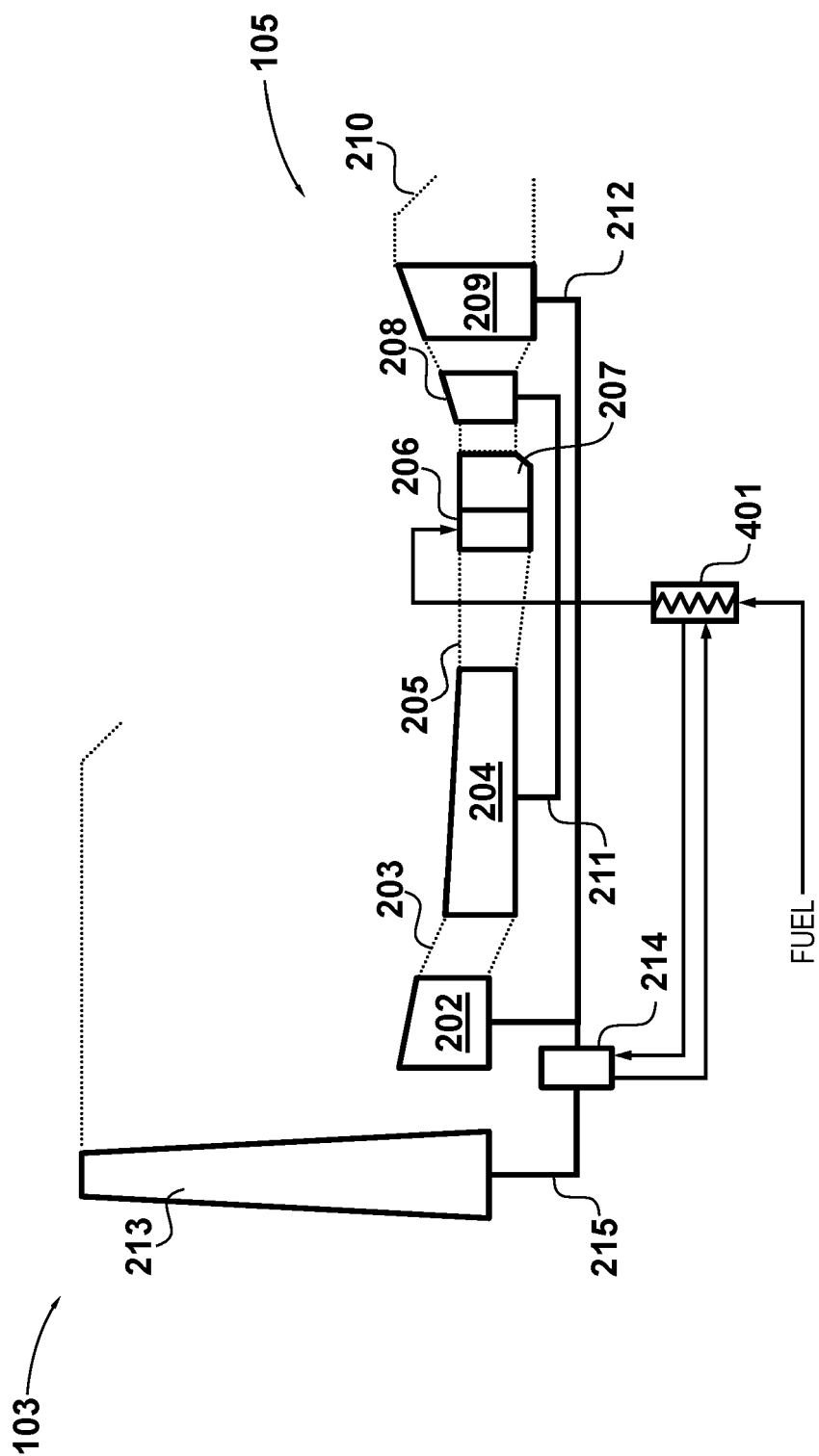


FIG. 4

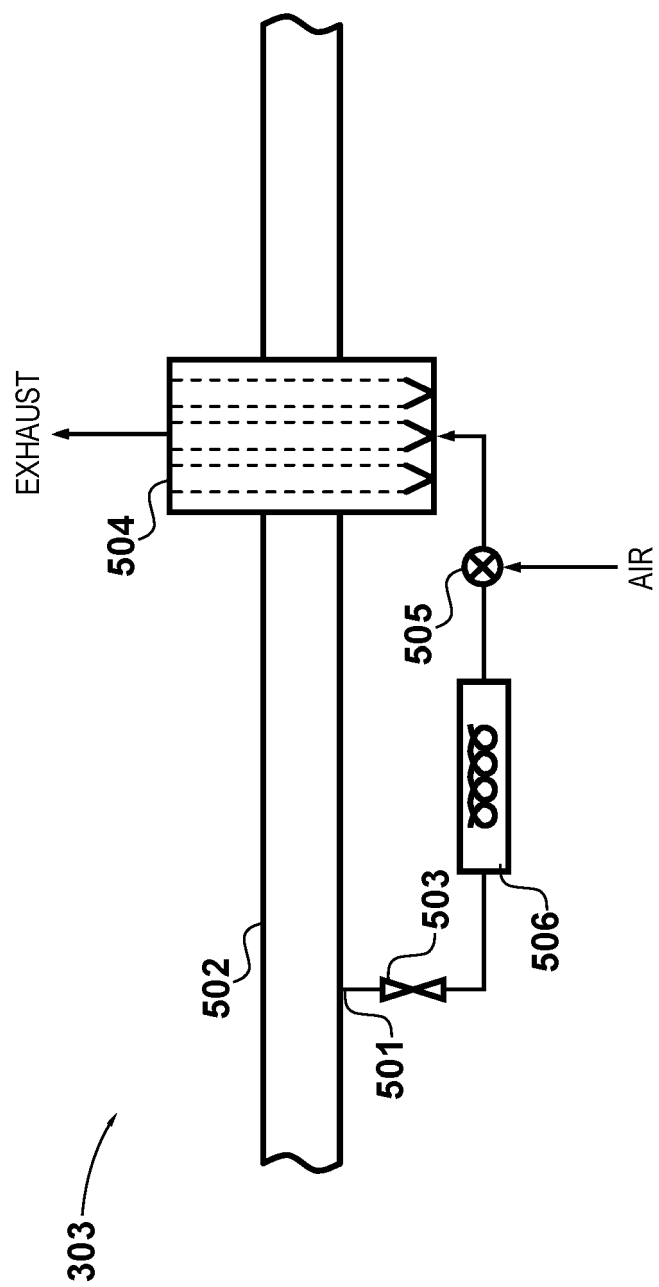


FIG. 5

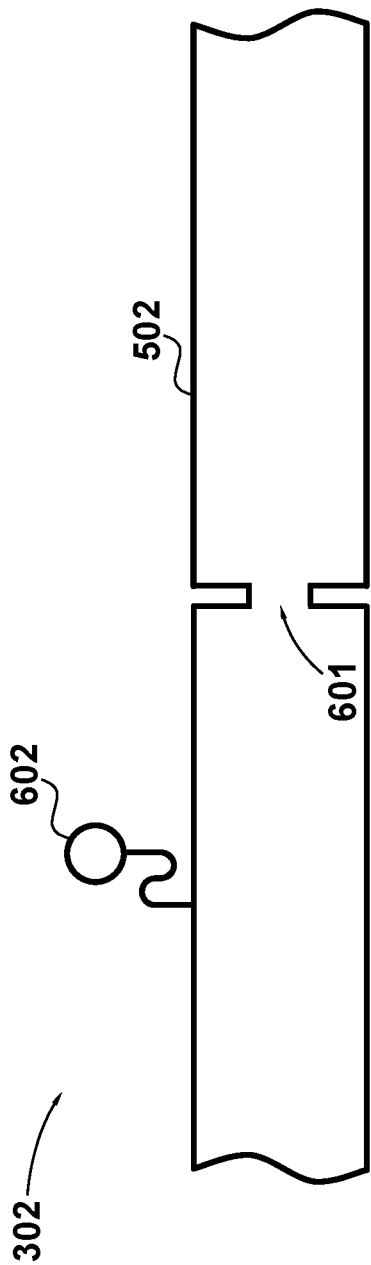


FIG. 6

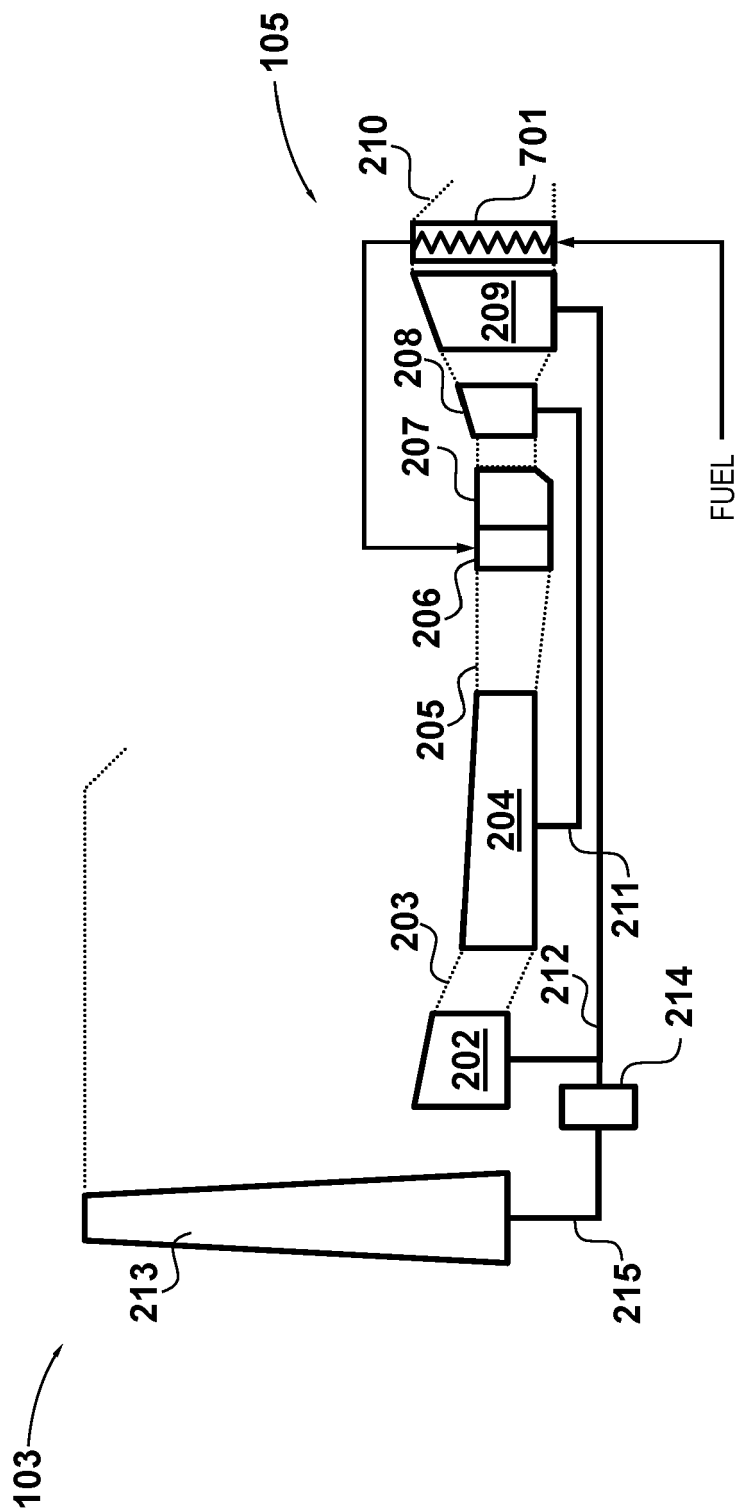


FIG. 7

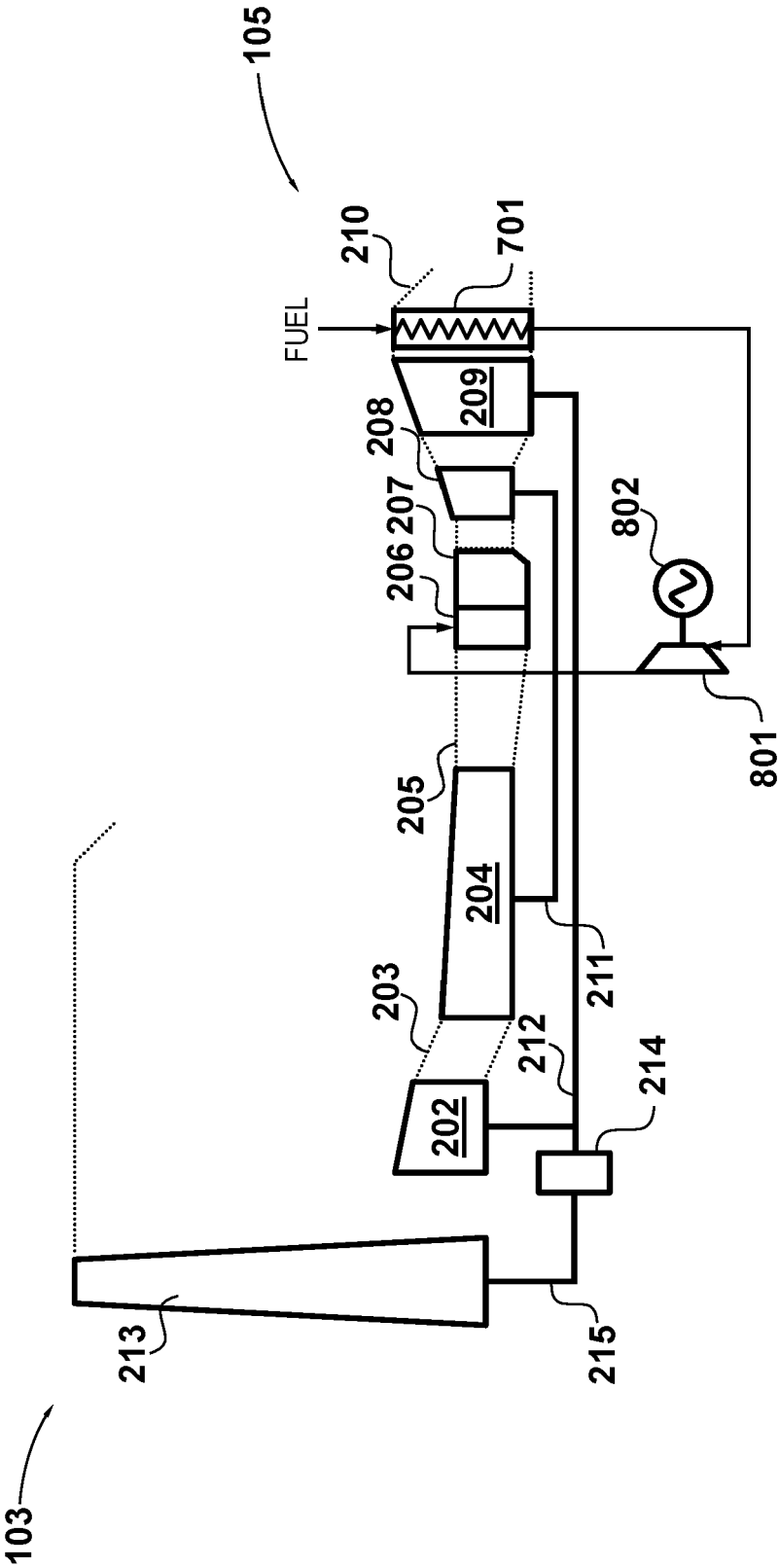


FIG. 8

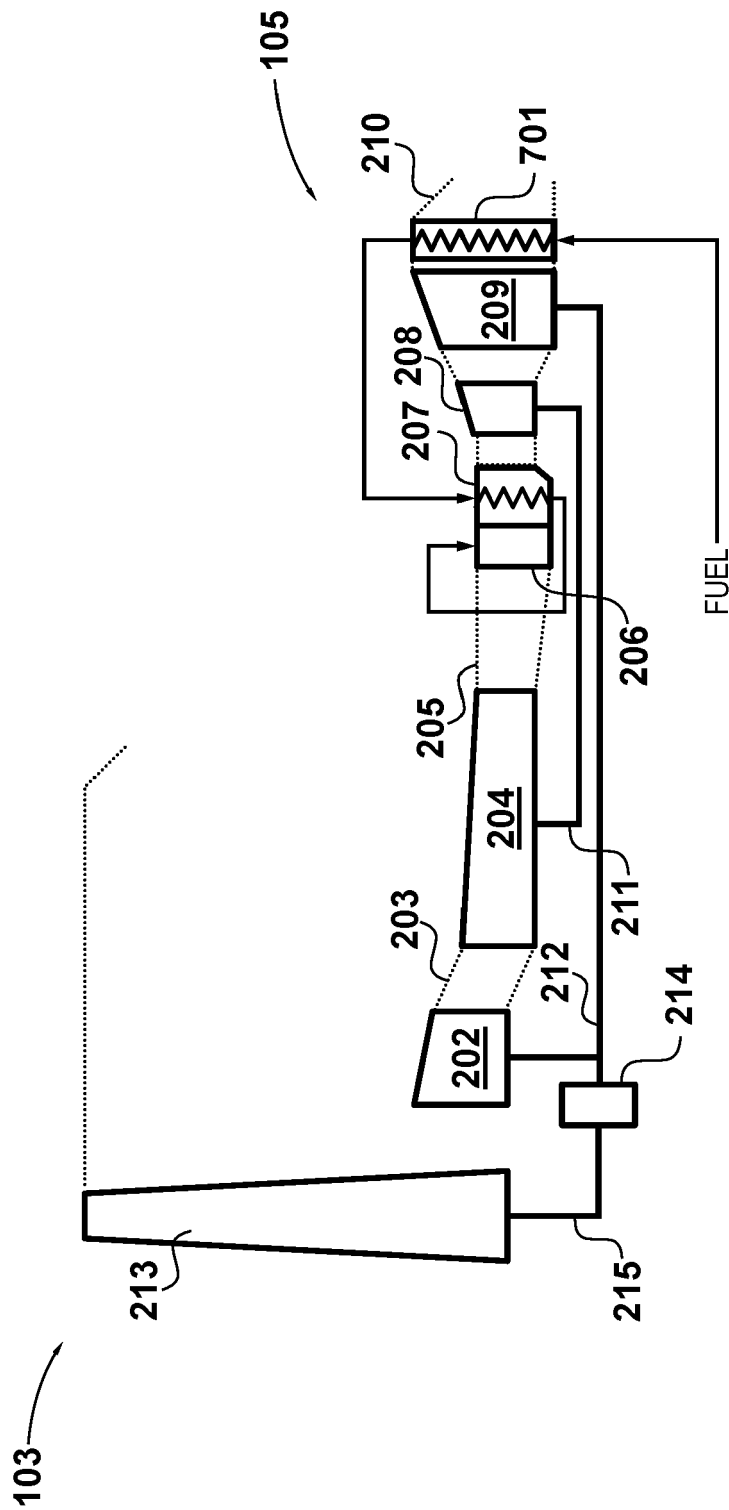


FIG. 9

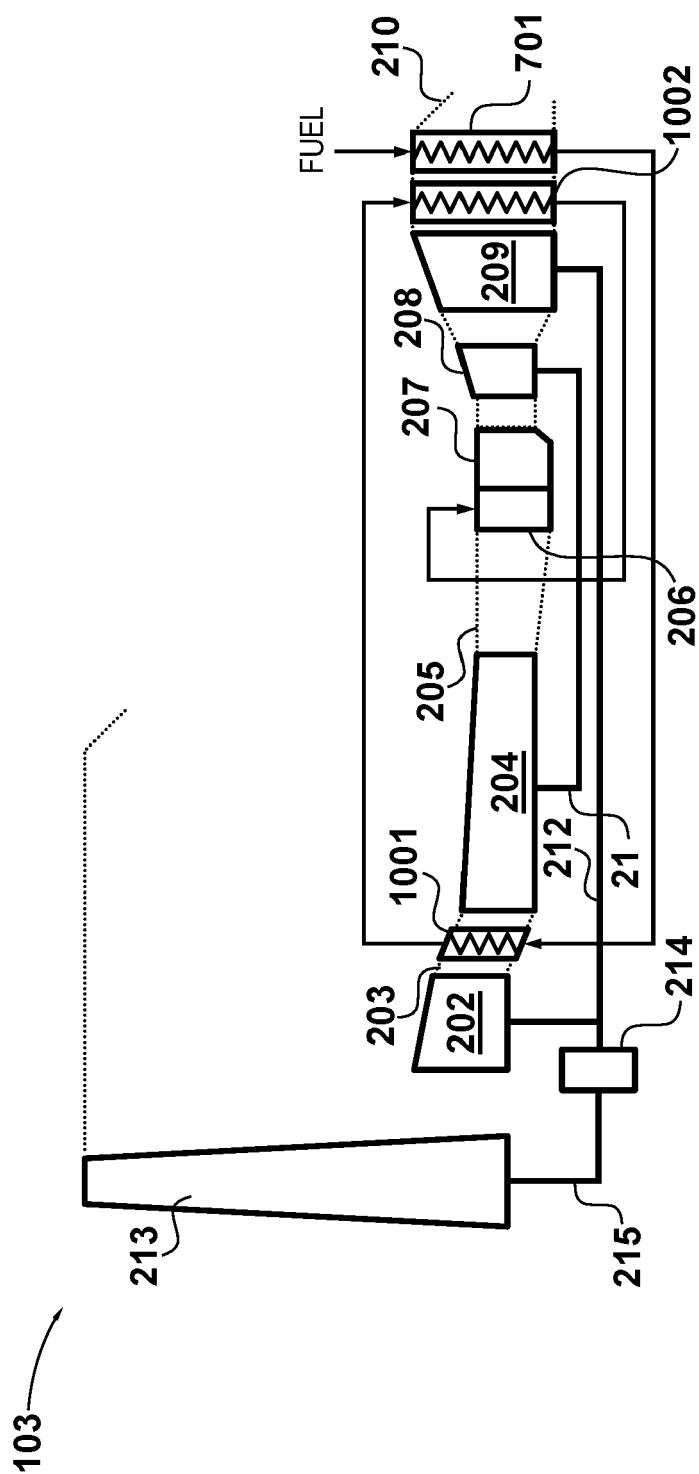


FIG. 10

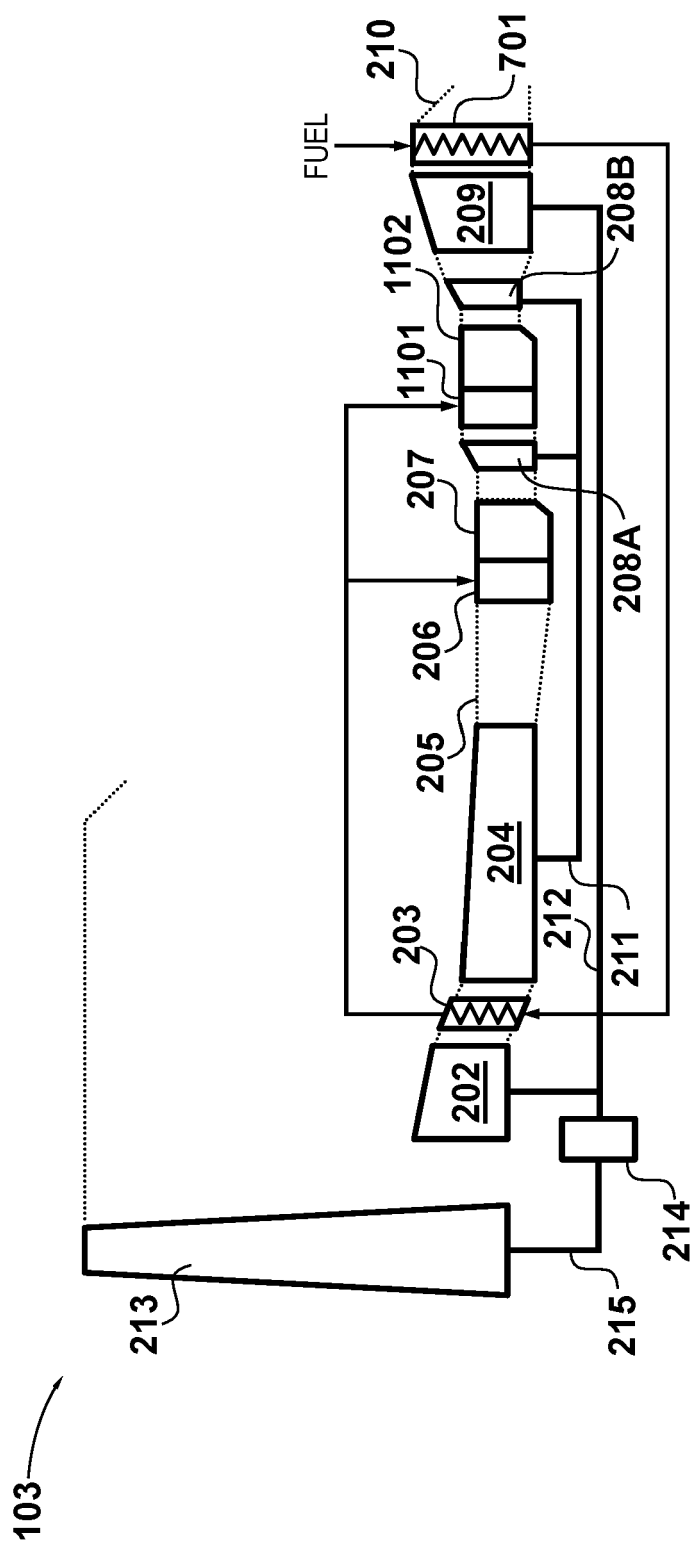


FIG. 11

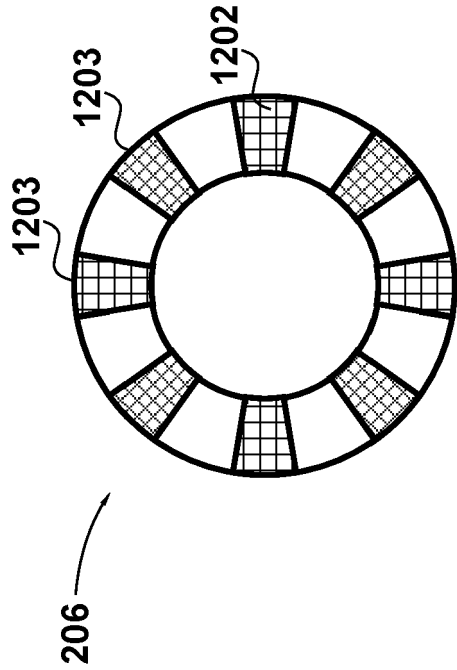


FIG. 12B

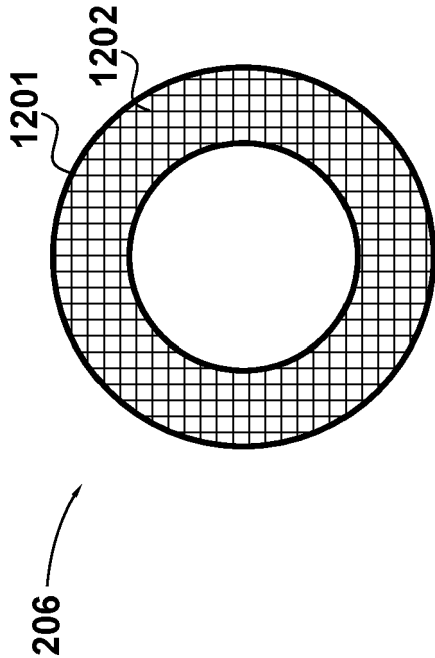


FIG. 12A

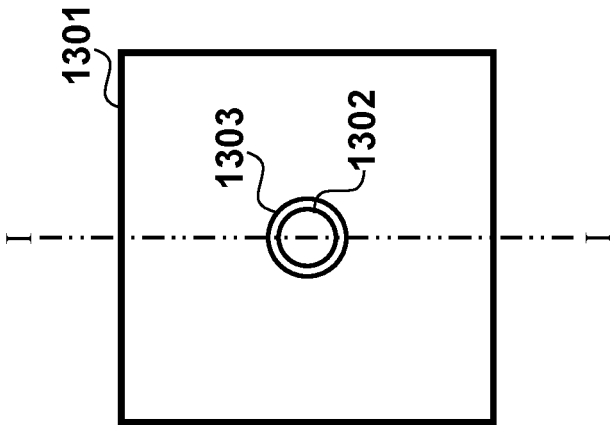


FIG. 13A

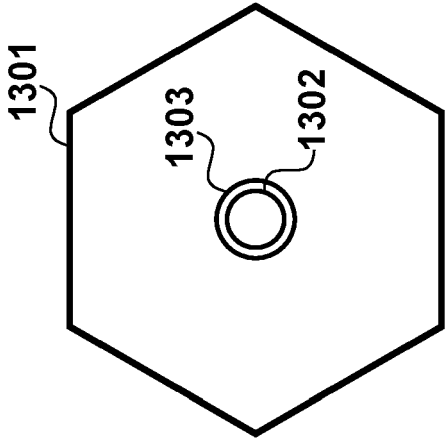
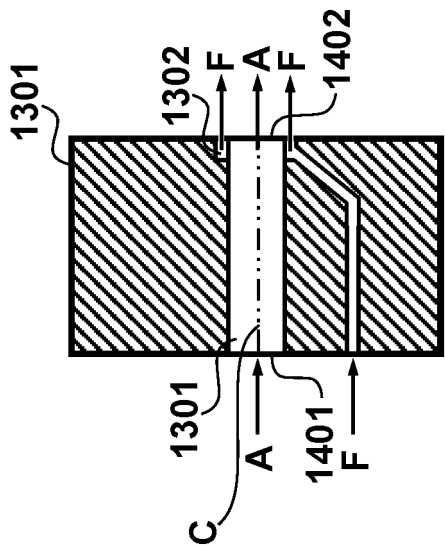


FIG. 13B



SECTION I-I

FIG. 14A

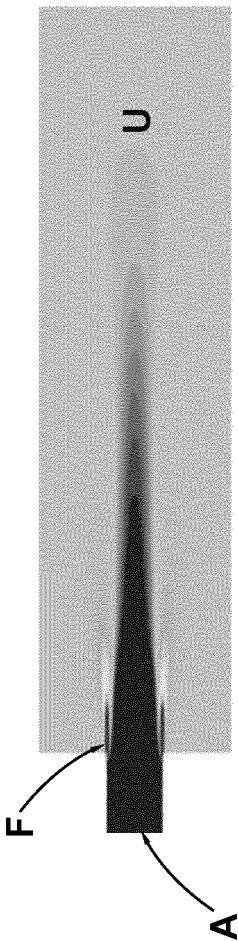
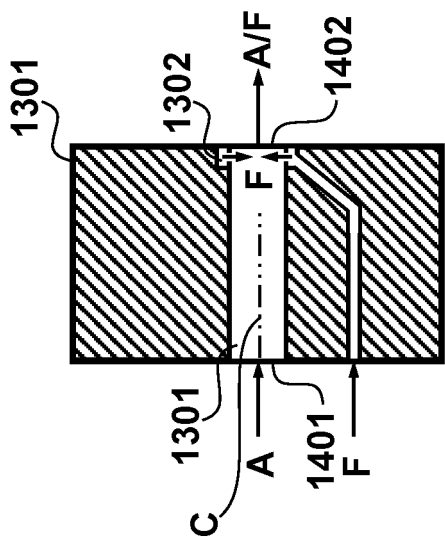


FIG. 14B



SECTION I-I

FIG. 14A

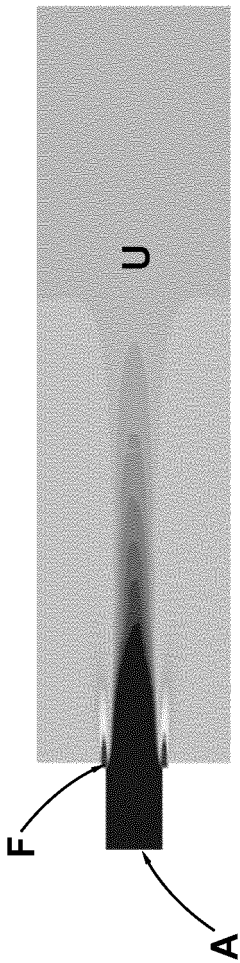


FIG. 14B

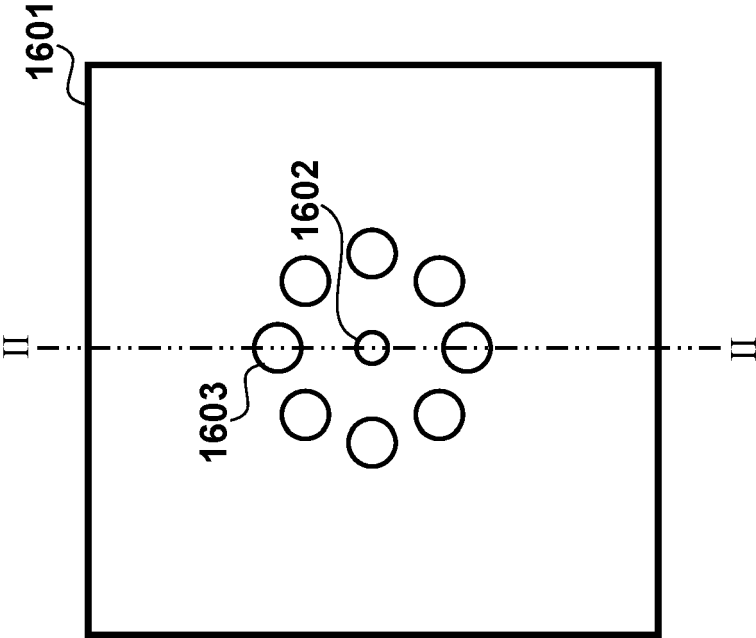
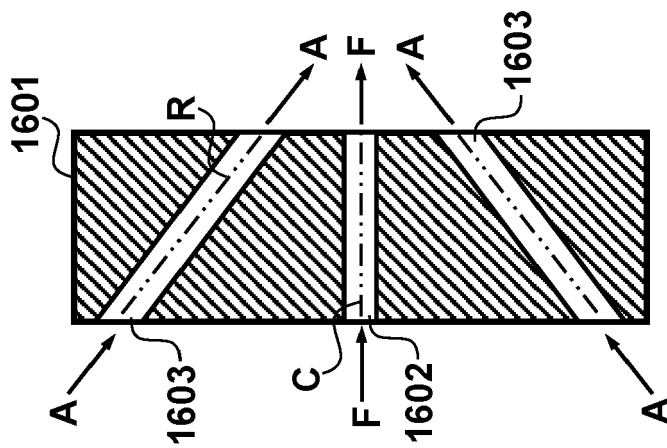


FIG. 16



SECTION II-II

FIG. 17A

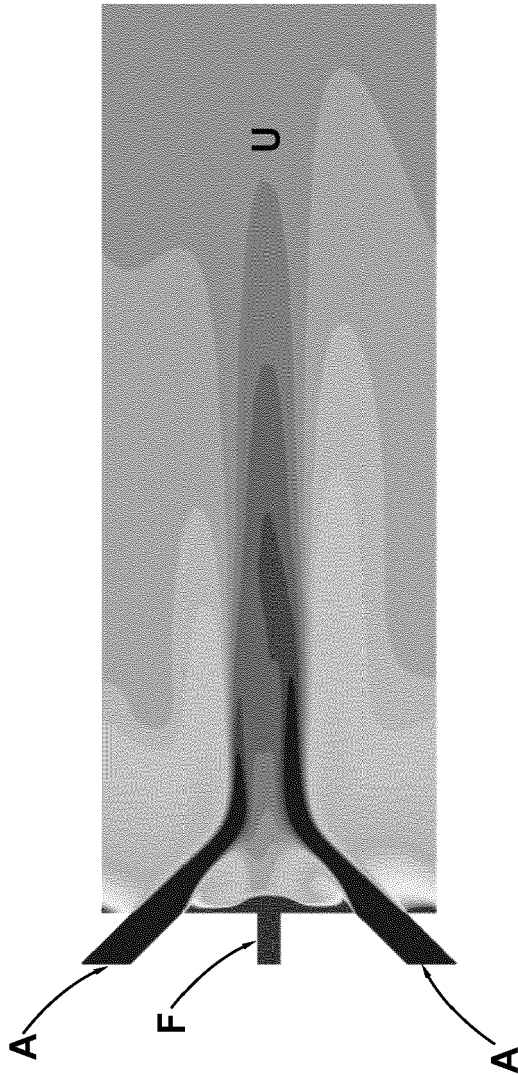


FIG. 17B

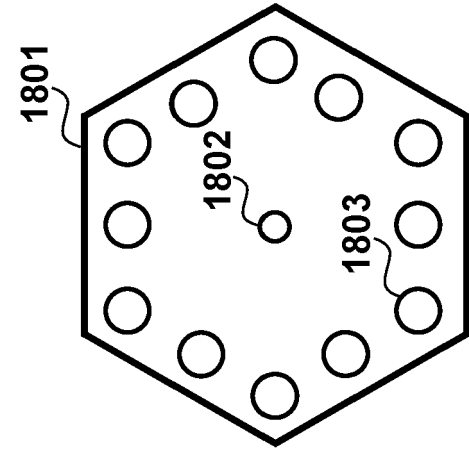


FIG. 18A

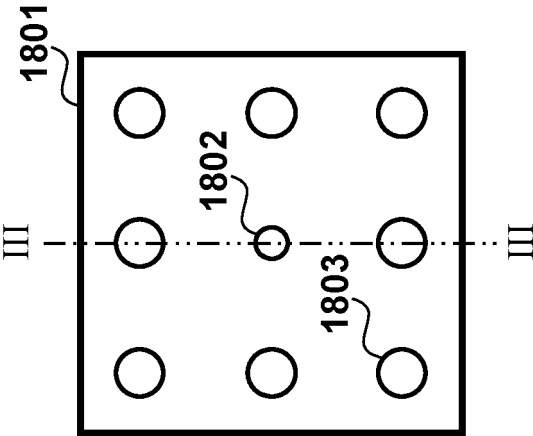
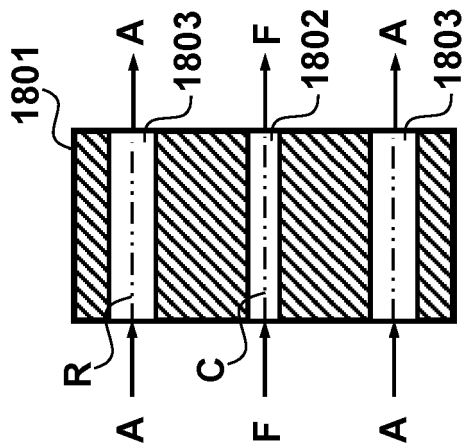


FIG. 18B



SECTION III-III

FIG. 19A

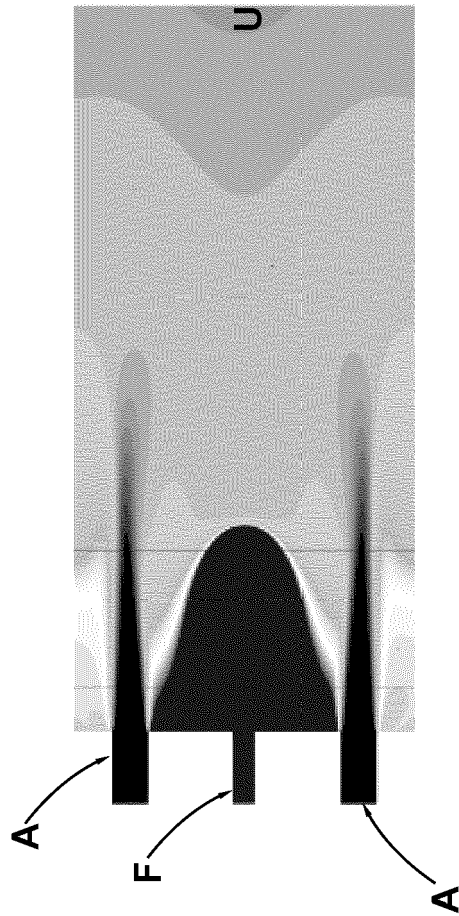


FIG. 19B

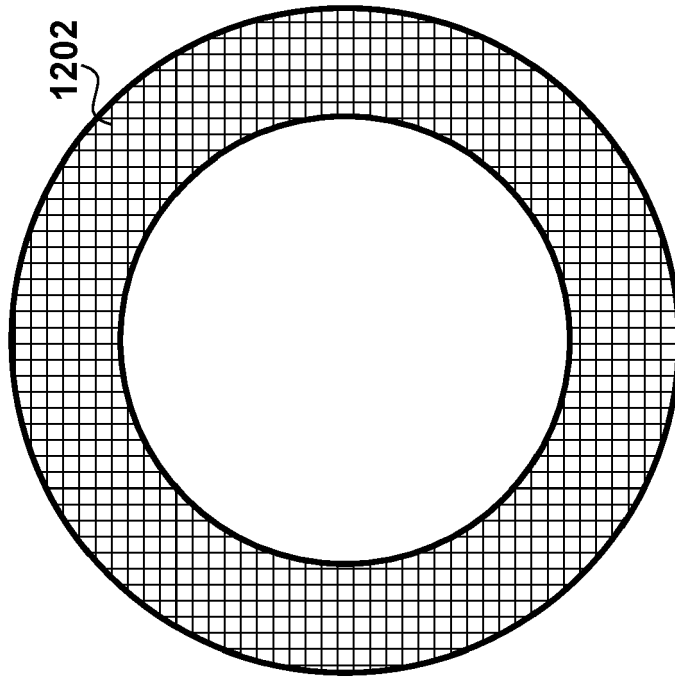


FIG. 20B

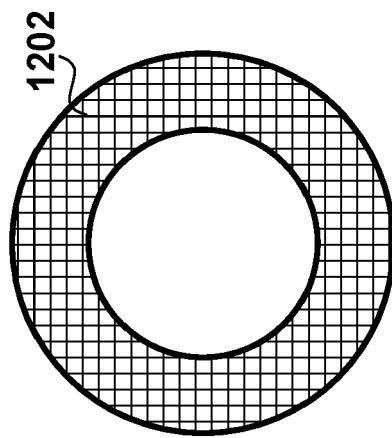


FIG. 20A



EUROPEAN SEARCH REPORT

Application Number

EP 21 19 6322

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EPO FORM 1503 03.82 (P04C01)

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A	* paragraph [0028] - paragraph [0045] * * paragraph [0103] * * paragraph [0122]; figures 2, 4, 18 *	3-5, 9, 13, 15	F02C7/224 F02C9/26

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X	US 6 079 222 A (FETESCU MIRCEA [CH] ET AL) 27 June 2000 (2000-06-27) * column 1, line 6 - line 10 * * column 4, line 36 - column 6, line 50; figures 1, 2, 4 *	1-15	

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X	EP 3 623 604 A1 (UNITED TECHNOLOGIES CORP [US]) 18 March 2020 (2020-03-18) * paragraph [0011] - paragraph [0054]; figures 1-3 *	1, 2, 6-8, 10-12, 14	TECHNICAL FIELDS SEARCHED (IPC) F02C

The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 2 February 2022	Examiner Robelin, Bruno
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

ANNEX TO THE EUROPEAN SEARCH REPORT ON EUROPEAN PATENT APPLICATION NO.

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